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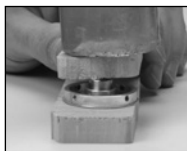
Velineon 380 Motor Rebuild Instructions

Covers Part #3372, #3373

Removing and installing the end bell bearings

1. Remove the 2x6 CCS and remove the end bell. Use a 1/4" punch* and a plastic mallet to tap the bearing out of the end bell. Repeat the process for the bearing on the output shaft side of the motor can. Discard the old bearings.
2. Assemble the rotor with the two shims and a new bearing in the proper order (see drawing) and install the rotor assembly in the motor can. The magnetic force will pull the rotor through the can and place the bearing in its recess. Lightly tap the end of the rotor with the handle of a screw driver until the bearing fully seats.

3. Place the end bell "outside down" on a wood block. Place the new bearing in the end bell housing. Place another wood block on top of the bearing and tap the bearing into the end bell with a plastic mallet. Make sure the bearing is fully seated.

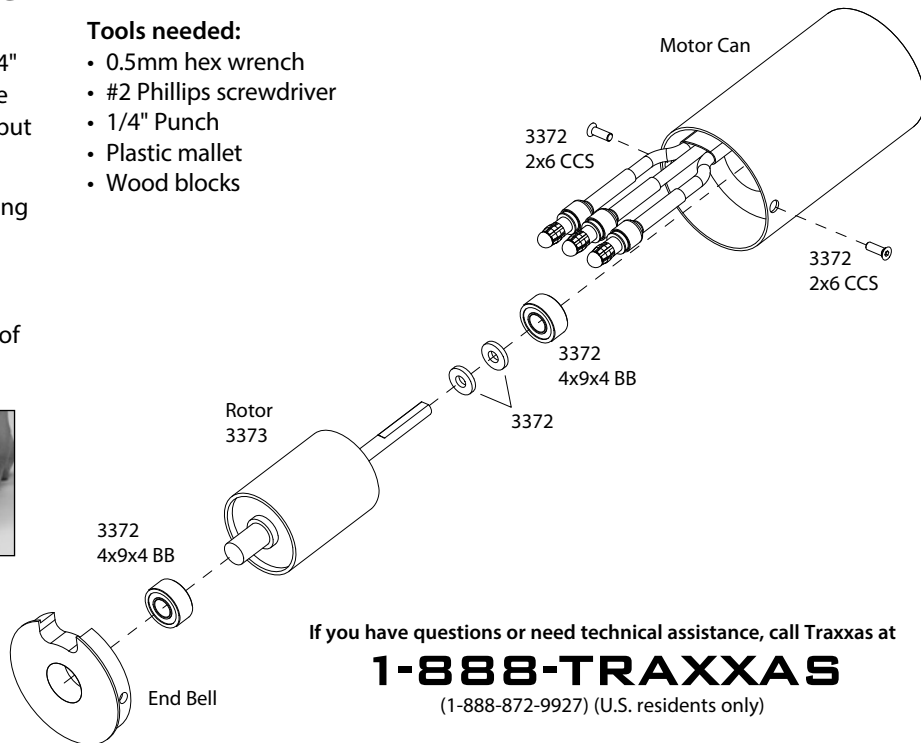


Note: The rotor contains a very powerful Neodymium magnet and should be kept away from any magnetic based storage devices, credit cards, monitors, etc.

*If you don't have a 1/4" punch, a #2 phillips head screwdriver can also be used.

Tools needed:

- 0.5mm hex wrench
- #2 Phillips screwdriver
- 1/4" Punch
- Plastic mallet
- Wood blocks



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